



# Instruction Sheet

## Model SB1215, SB1216, SB1217

### Precision Drill Press Vice



## ! WARNING

Models SB1216 and SB1217 are heavy! Get the assistance of a second person when lifting or placing the vise. Wear heavy duty leather boots for foot and toe protection, and keep hands and fingers away from all pinch points. Ignoring this warning can lead to a severe crushing injury or finger amputation!



## Specifications

Hardened Steel Jaws .....	Yes
Hand-Scraped Ways .....	Yes
Leadscrew Type .....	Acme Thread
Epoxy Paint .....	Yes
Net Weight (SB1215) .....	18.5 lbs.
Net Weight (SB1216) .....	39.05 lbs.
Net Weight (SB1217) .....	75.05 lbs.

## Operation

1. Place the vise on a clean and lightly-oiled drill press table. Rub the vise base in a circular motion once or twice on the table to fully seat the vise with the table.
2. Clamp or bolt the vise to the table. Do not overtighten the clamps or fasteners.
3. Position the workpiece between the jaws and tighten the jaws with the handle. Never use a cheater pipe to increase leverage, or you may damage the vise. If you like, unthread the knob and remove the handle (**Figure 1**), so that a socket and ratchet can be used on the end of the leadscrew drive hex. However, never use any type of impact wrench to tighten the leadscrew.

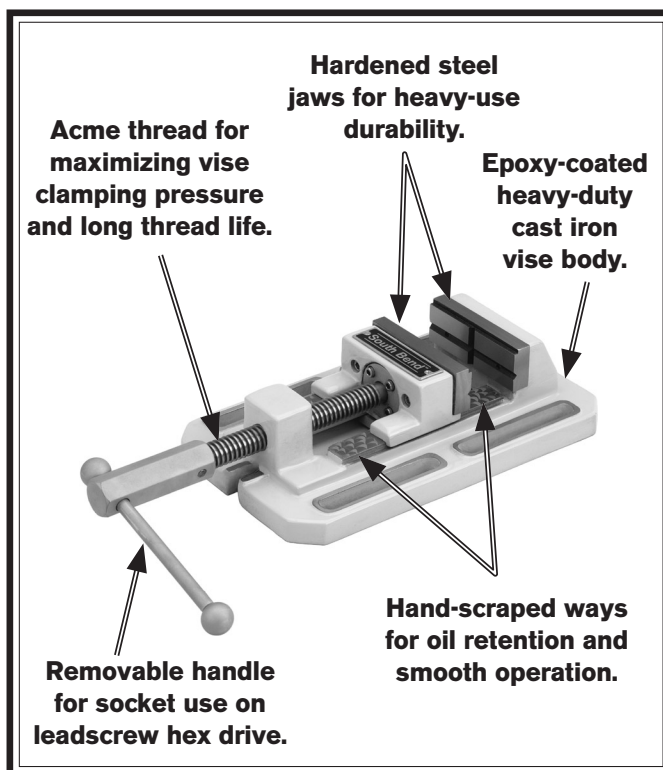


Figure 1. Features.

## Care & Maintenance

- Keep leadscrew and ways clean and oiled.
- Avoid leaving the vise clamped to a cast iron table—moisture may get trapped and rust between mating surfaces.
- Stone away any burrs in the jaws or leadscrew threads.
- Never hammer on vise or a workpiece clamped in vise.
- Never subject vise to flame or water.

*If you need help, contact us at:*

**PHONE: (360) 734-1540**

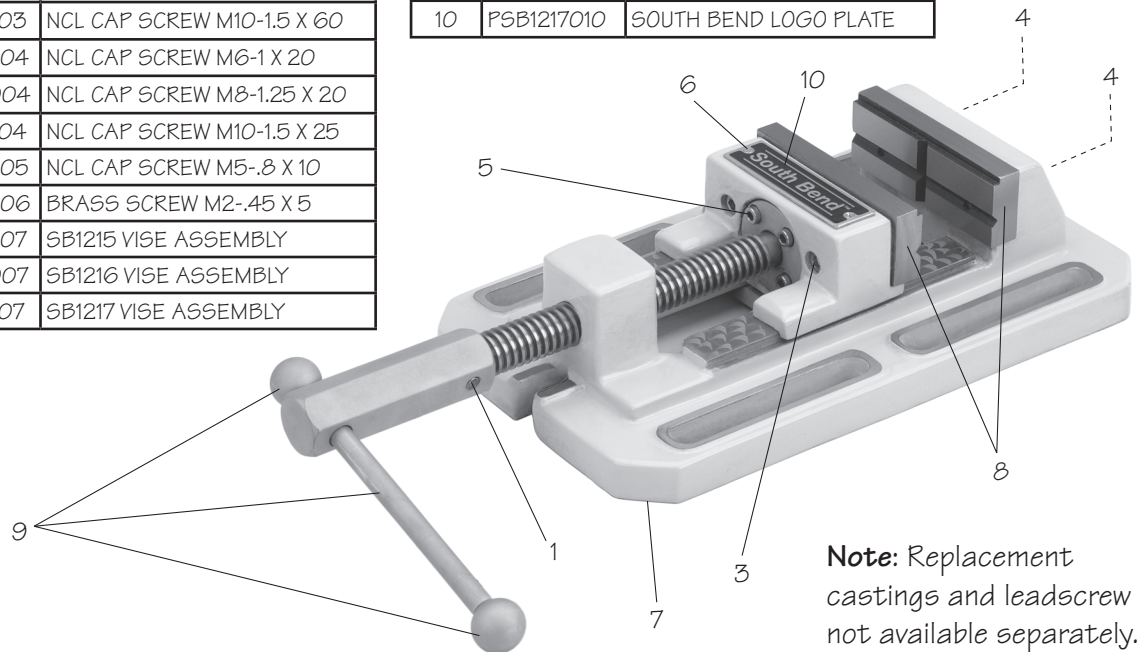
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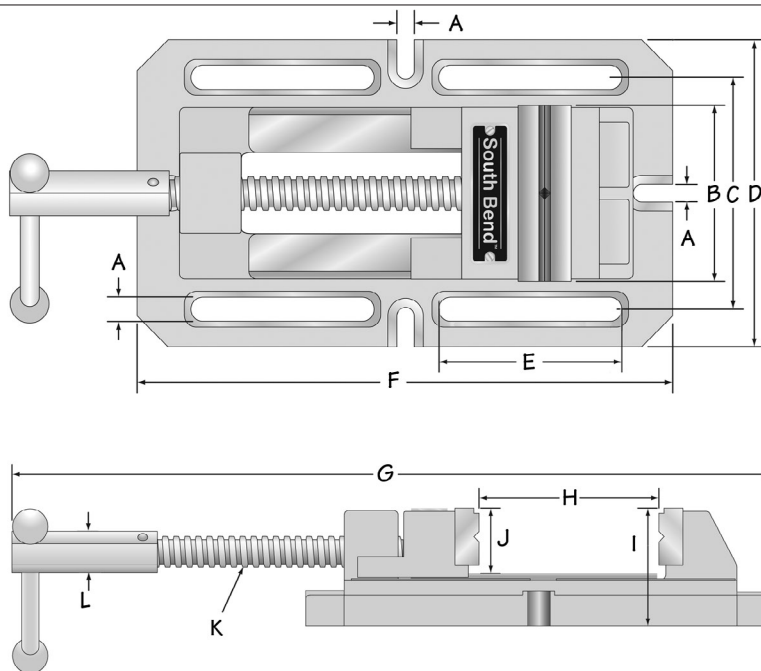
Model: SB1215, SB1216, SB1217 Parts		
Item	Part#	Description
1	PSB1215001	DOWEL PIN 5 X 30MM
	PSB1216001	DOWEL PIN 5 X 30MM
	PSB1217001	DOWEL PIN 8 X 40MM
3	PSB1215003	NCL CAP SCREW M6-1 X 35
	PSB1216003	NCL CAP SCREW M8-1.25 X 40
	PSB1217003	NCL CAP SCREW M10-1.5 X 60
4	PSB1215004	NCL CAP SCREW M6-1 X 20
	PSB1216004	NCL CAP SCREW M8-1.25 X 20
	PSB1217004	NCL CAP SCREW M10-1.5 X 25
5	PSB1215005	NCL CAP SCREW M5-.8 X 10
6	PSB1215006	BRASS SCREW M2-.45 X 5
7	PSB1215007	SB1215 VISE ASSEMBLY
	PSB1216007	SB1216 VISE ASSEMBLY
	PSB1217007	SB1217 VISE ASSEMBLY

Item	Part#	Description
8	PSB1215008	SB1215 JAW SET
	PSB1216008	SB1216 JAW SET
	PSB1217008	SB1217 JAW SET
9	PSB1215009	SB1215 LEVER ASSEMBLY
	PSB1216009	SB1216 LEVER ASSEMBLY
	PSB1217009	SB1217 LEVER ASSEMBLY
10	PSB1217010	SOUTH BEND LOGO PLATE



**Note:** Replacement castings and leadscrew not available separately.

**Figure 2. Parts list and diagram.**



Vise Dimensions Table			
	SB1215	SB1216	SB1217
A	1/2"	5/8"	5/8"
B	4"	5 1/2"	7 7/8"
C	5 3/8"	7 1/2"	9 7/8"
D	6 3/4"	9 1/8"	11 1/2"
E	4"	4 1/2"	7"
F	11 3/8"	14 7/8"	19 3/16"
G	18 1/2"	24"	31 1/2"
H	4 3/8"	6"	8"
I	3"	3 1/2"	4"
J	1 5/8"	2"	2 1/2"
K	4 TPI	5 TPI	6 TPI
L	1" (25mm)	1 3/16" (30mm)	1 9/16" (40mm)

**Figure 3. Vise dimensions.**